

NCR-19-7558



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Canada

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RBEA62309-4
Job Sheet 193397



Part No: RBEA62309-4

Job Qty: 10 pcs

Part Name: Stiffener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/15/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62309 Rev.T IPP Rev. A 19.02.01 New issue DP Verify DD/IPP Rev.B 19.02.28 drawing revision
DP Verify DD/IPP Rev. C 19.04.01 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	5/3/19	5/3/19	0.00	2.50	Waterjet - Flow		DL 19/05/15
110	QC 2	10 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DL 19/05/15
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 4/15/19 8:28 AM Dart.lajeunesse.marie

120 QC 8	10 pcs	5/3/19	0.00 0.00	QC 2 - 65					
				QC 2 - 5					
				QC 2 - 71					
				QC 8 - 12					
				QC 8 - 14					
				QC 8 - 17					
				QC 8 - 20					
				QC 8 - 25					
				QC 8 - 3					
				QC 8 - 32					
				QC 8 - 33					
				QC 8 - 35					
				QC 8 - 39					
				QC 8 - 4					
				QC 8 - 44					
				QC 8 - 45					
				QC 8 - 49					
				QC 8 - 58					
				QC 8 - 8					
				QC 8 - 9					
				QC 8 - 68					
				QC 8 - 67					
				130 Packaging 3-1 - Stock - B4B	10 pcs	5/3/19	0.00 0.00	QC 8 - 1 (A)	
								QC 8 - 47	
QC 8 - 40									
QC 8 - 52									
QC 8 - 23									
130 Packaging 3-1 - Stock - B4B	10 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B					
				Packaging 3 - 2 - B4B					
				Packaging 3 - 3 - B4B					
				Packaging 3 - 4 - B4B					
				Packaging 3 - 5 - B4B					
140 QC 21 - SA	10 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21					
				QC 21 - SA - 70					
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>T</u> PROG. Rev: <u>T</u> 2-Deburr if necessary Descriptions: 130 - .					MAY 17 2019 MAY 21 2019				
Job BOM									
Part / Item	Component Name	Quantity	Operation	Container					
M6061T6S.040	6061-T6 .040 Sheet	47.7000 sf (4.77 ea)	100-Waterjet - Flow - 1	S153360 X3 S176561 X8					
Job Allocations									
Operation	Component Part	Required	Inventory	Allocated					
100-Waterjet - Flow - 1	M6061T6S.040	48	194	0					
Part Specifications									
Specifications could not be found.									

DART AEROSPACE LTD		Work Order:	193399
Description: <i>Stiffener</i>		Part Number:	
Inspection Dwg: <i>RBEA62309-4</i>	Rev: <i>T</i>	Page 1 of 1	

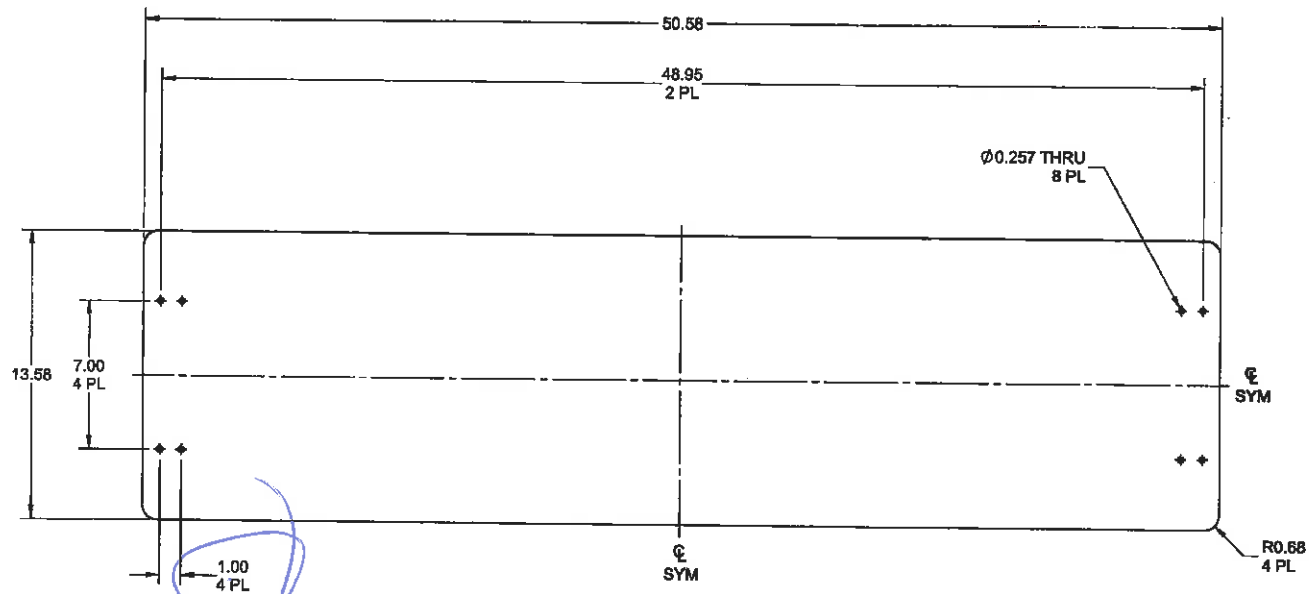
INSPECTION SHEET

[illegible]

Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (if necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RBEA62309-4 STIFFENER

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

NO. 193377 MMS
R.04-15

DESIGN DRAWN CHECKED MPG. APPR. APPROVED DATE	KPT KPT KPT DP Wp 3/27/2019	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBEA62309 TITLE AS350/355 FIELD MAINTENANCE KIT COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND CONTAINS INFORMATION IS SUPPLIED ON THE ASSUMPTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY BASIS UNLESS IT IS SPECIFICALLY AUTHORIZED BY DART AEROSPACE LTD.	REV. T SHEET 7 OF 11 SCALE NTS
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Container No: S181711



Part: RBEA62309-4

Job No: 193397

Serial No/Batch: S181711

Revision: T

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K8A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/16/19

Elity Assurance

Entered: JKDate: Oct 24/19NCR No. 19-7558

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>193397</u> Part No. <u>RBEAG2309</u> <u>REV T</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>2019-05-16</u>		Sequence #:		QTY Affected: <u>21</u>		MRB (QSI042) <u>Wp</u> <u>19-05-16</u>	
Description Work Order Deviation				Disposition			
- DIMENSION 1.00 4PL IS CUT AT 0.950 - 0.95 IS ACCEPTABLE				- THIS DEVIATION IS ACCEPTABLE TO USE AS IS - FIT FORM AND FUNCTION WILL BE AS ORIGINALLY INTENDED		Completed By <u>MAY 16 2019</u> <u>40</u> <u>9-89</u> Lead hand / Supervisor DAS <u>30</u> <u>9-89</u> <u>19-05-16</u> QC / QA Coordinator DAS <u>68</u> <u>9-89</u> <u>MAY 16 2019</u>	
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					